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D3202-1
Job Sheet 200132



Part No: D3202-1

Job Qty: 10 pcs

Part Name: Cover



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/6/19

Job Tracking No:

Due Date: 10/11/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV D IPP Rev:B No Longuer Made In House 05-11-06 JLM IPP Rev:C Now on Waterjet 07-04-18 JLM
IPP Rev:D chg to revC as per dwg 08-04-21 DD verified by:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	10 pcs		10/11/19	0.17	1.19	Waterjet - Flow		TF March 3, 2020
120	QC 8	10 pcs		10/11/19	0.00	0.00	QC 8 - 12		
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		MAR 04 2020 9:45
							QC 8 - 52		
							QC 8 - 23		
							QC 8 - 57		
130	Handfinish - 1-1 Chemical-B4B	10 pcs		10/11/19	0.00	0.77	Handfinish - 1 - 1 - B4B		
							Handfinish - 1 - 2 - B4B		

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					Handfinish - 1 - 3 - B4B	MAR 09 2020
					Handfinish - 1 - 4 - B4B	
					Handfinish - 1 - 5 - B4B	
					Handfinish - 1 - 6 - B4B	
					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
140	Powdercoat - 3 Grey Sand - B4B	10 pcs	10/11/19	0.00 0.57	Powdercoat - 1 - B4B	BIB20-03-09
					Powdercoat - 2 - B4B	
					Powdercoat - 3 - B4B	
					Powdercoat - 4 - B4B	
150	QC 3	10 pcs	10/11/19	0.00 0.00	QC 3 - 10	DAS 40 MAR 09 2020 8-89
					QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 68	
					QC 3 - 9	
					QC 3 - 40	
					QC 3 - 19	

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				QC 3 - 43	
				QC 3 - 24	
				QC 3 - 61	
				QC 3 - 81	
160	Packaging 3-1 - Stock - B4B	10	10/11/19	0.00 0.00	Packaging 3 - 1 - B4B
	pcs				Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B
					Packaging 3 - 23 - B4B
					Packaging 3 - 24 - B4B
					Packaging 3 - 25 - B4B
					Packaging 3 - 26 - B4B
					Packaging 3 - 27 - B4B
					Packaging 3 - 28 - B4B
					Packaging 3 - 29 - B4B
					Packaging 3 - 30 - B4B
					Packaging 3 - 31 - B4B
					Packaging 3 - 32 - B4B
					Packaging 3 - 33 - B4B
					Packaging 3 - 34 - B4B
					Packaging 3 - 35 -

				B4B	
				Packaging 3 - 36 - B4B	
170 QC 21 - SA	10 pcs	10/11/19	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	DAS
				QC 21 - SA - 53	21
					MAR 10 2020

Part Op 100 - 1-Cut as per Dwg D3202 2-Deburr if necessary
 Descriptions: 120 - (QC8- Inspect parts - second check)
 130 - (Chemical Conversion Coat per QSI005 4.1)
 140 - (Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3) START TIME: 10:20 TEMP: 320° FINISH: 10:50
 150 - (QC3- Inspect Part Finish)
 160 - (Identify as per dwg & Stock Location: _____)
 170 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M5052H32S.032	5052-H32 .032 Sheet	15.5100 sf (1.551 ea)	100-Waterjet - Flow - 1	S152147
				S167935

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M5052H32S.032	16	93	0

6061TB Co attached to

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Cover	0.380inches + 0.006 - 0.001	0.386 0.379	0.380	
2	Cover	0.630inches ± 0.030	0.660 0.600	0.620	
3	Cover	3.380inches ± 0.030	3.410 3.350	3.377	
4	Cover	2.400inches ± 0.030	2.430 2.370	2.392	
5	Cover	0.820inches ± 0.030	0.850 0.790	0.803	
6	Cover	73.840inches ± 0.030	73.870 73.810	73.840	
7	Cover	74.500inches ± 0.030	74.530 74.470	74.500	
8	Cover	0.032inches ± 0.010	0.042 0.022	0.034	
9	Cover	4.030inches ± 0.030	4.060 4.000	4.031	

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Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐



Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Machining ☐ Small Fab ☐ Large Fab ☐ Finishing ☐		Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐		Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐					
Date :		Sequence #:		QTY Affected :		MRB (QS1042)							
Description Work Order Deviation						Disposition							
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐						FAULT CATEGORY Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐				Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐			
						Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐				Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐			
						Other/Details:							
						Completed By _____ Lead hand / Supervisor _____ QC / QA Coordinator _____							

TO: Patrick Duval <pdual@dartaero.com>; Linda Lacelle <llacelle@dartaero.com>; Steven Drouin <sdrouin@dartaero.com>

Cc: Marcel Daviau <mdaviau@dartaero.com>; Robert Aboud <raboud@dartaero.com>; Jean-Luc Menard <jmenard@dartaero.com>

Subject: RE: quote

It is acceptable to substitute 6061-T6 sheet for 5052-H32 sheet. The part's work order will have to be deviated.

If we're having a general procurement issues, we may want to update QSI 017 to add 6061-T6 as an alternative to 5052-H34.

-Chris

From: Patrick Duval <pdual@dartaero.com>

Sent: Thursday, December 05, 2019 4:47 PM

To: Linda Lacelle <llacelle@dartaero.com>; Chantal Lavoie <clavoie@dartaero.com>; Steven Drouin <sdrouin@dartaero.com>; Marcel Daviau <mdaviau@dartaero.com>; Robert Aboud <raboud@dartaero.com>; Jean-Luc Menard <jmenard@dartaero.com>

Cc: Marcel Daviau <mdaviau@dartaero.com>; Robert Aboud <raboud@dartaero.com>; Jean-Luc Menard <jmenard@dartaero.com>

Subject: RE: quote

Chris,

As per email below can you give me your opinion on this.

Pat Duval

From: Patrick Duval

Sent: December 5, 2019 3:47 PM

To: Jean-Luc Menard <jmenard@dartaero.com>; Linda Lacelle <llacelle@dartaero.com>; Chantal Lavoie <clavoie@dartaero.com>; Marcel Daviau <mdaviau@dartaero.com>; Robert Aboud <raboud@dartaero.com>; Steven Drouin <sdrouin@dartaero.com>

Subject: RE: quote

Steve,

Is it possible to substitute 5052 for some 6061. We are not able to get 5052 anywhere else but from china.

Pat Duval

<raboud@dartaero.com>

Cc: Patrick Duval <pduval@dartaero.com>

Subject: RE: quote

Just remember we cannot cut 5052 on the WJ , it delaminates

From: Linda Lacelle <llacelle@dartaero.com>

Sent: Thursday, December 5, 2019 10:41 AM

To: Chantal Lavoie <clavoie@dartaero.com>; Marcel Daviau <mdaviau@dartaero.com>; Robert Aboud <raboud@dartaero.c

Cc: Patrick Duval <pduval@dartaero.com>; Jean-Luc Menard <jmenard@dartaero.com>

Subject: RE: quote

Or maybe 6061T6 would be ok to use?

From: Chantal Lavoie <clavoie@dartaero.com>

Sent: Thursday, December 5, 2019 10:38 AM

To: Marcel Daviau <mdaviau@dartaero.com>; Robert Aboud <raboud@dartaero.com>

Cc: Patrick Duval <pduval@dartaero.com>; Linda Lacelle <llacelle@dartaero.com>; Jean-Luc Menard <jmenard@dartaero.c

Subject: FW: quote

Good morning,

I have been asking for a quote on the following mat'l, M5052H32 sheet .032".

The mat'l quoted all come from China, please advise if this would be acceptable or we would need an update for the follow

D3202-1

~~D3202-3~~

D3641-1

D3641-3

~~D3641-4~~

Thanks

Chantal

